

Date: Tuesday, 23/12/2008 1:24:25 PM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MOD KIT
 Job Number : 44314 -1
 Estimate Number : 11182
 P.O. Number :
 Part Number : D350615041
 This Issue : 23/12/2008 S.O. No. :
 Drawing Number : D350-615
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : B
 Previous Run : 43556 Material :
 Due Date : 30/01/2009 Qty: 60 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:K Removed Manufacturing 05-12-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

2.0 44314A "T" HANDLE ASSEMBLY



Comment: Sub-Component "T" HANDLE ASSEMBLY

1 x D2282-041 Batch B43400 x3

B4440-3A x50

3.0 44314B SADDLE ASSEMBLY



Comment: Sub-Component SADDLE ASSEMBLY

1 x D2282-043 Batch B44314

4.0 D30153 Locknut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 180.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3015-3 5/16 Locknut 44328x

5.0 D30155 SS Nylock Nut 7/16



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-5 7/16 Locknut B41899

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Drawing Name: GHW MOD KIT

Job Number: 44314

Part Number: D350615041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	51618015C	SS Bolt 5/16-18 1.5" L
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 180.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

M110438 x150

M107778 x32

SS 09/01/15 (X60)

7.0	516WC	SS Flat Washer 5/16
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 720.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

M109326 x20

M16138 x700

SS 09/01/15 (X60)

8.0	71614050C	SS Bolt 7/16 5" Long
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

M109340

SS 09/01/15 (X60)

9.0	716WC	SS Flat Washer 7/16
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref) "T" Handle Assembly

1 D2282-043 (Ref) Saddle Assembly

M107802

B44403

B44314B

B43400 (3) SS 09/01/15 (X60)

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

CP 09/02/03 (53)

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 02/02/03 (153) counter

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Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten: 02/02/03 (K26) (+D)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location: _____

PPP Rev: _____

Handwritten: R

Handwritten: 01/02/03

Handwritten: (53)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/02/04

Job Completion



Handwritten: 11/09/02/03

DART

DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>May</i>	APPROVED <i>BW</i>	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (<i>D3015-3</i>)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (<i>D3015-5</i>)
2	7/16WC	7/16 WASHER

who 434

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DW	DRAWN BY	KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	DM	APPROVED	KE	DRAWING NO. D350-615
DATE	97.10.21	TITLE	GROUND HANDLING WHEEL MOD.	REV. B SHEET 2 OF 2
		SCALE	NTS	

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

44314

EXISTING PUMP BODY

D2282-043 SADDLE ASSEMBLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries